

Date: Wednesday, 13/08/2008 10:10:36 AM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|-------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | AFT TUBE ASSEMBLY |
| Job Number : | 41193 | | |
| Estimate Number : | 10699 | | |
| P.O. Number : | | Part Number : | D3391025 |
| This Issue : | 13/08/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D3391 REV G |
| First Issue : | // | Project Number : | N/A |
| Previous Run : | 41192 | Drawing Revision : | G |
| | Type : | Material : | |
| | SKIDTUBES | Due Date : | 28/08/2008 |
| Written By : | | Qty: | 1 |
| Checked & Approved By : | <u>JLD 08.08.13</u> | Um: | Each |
| Comment : | Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev:C 06-03-28 Update Manuf. Instructions JLM est rev D 07.03.20 revF dwg EC est rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD Est Rev:F 07-11-13 ECN 1056 DD verified by: EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------|--------------------|
| 1.0 | D6014090 | ALUMINUM EXTRUSION |
|-----|----------|--------------------|



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

| | | | |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch |
| 1 | D6014-090 | Extrusion | <u>B32309</u> |

Identify as D3391-3

am 08.08.20 ①

| | | |
|-----|------------|----------------------------|
| 2.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|



Comment: MORI SEIKI CNC LATHE LARGE AA
 Turn as per Folio FA599 Rev: B & Dwg D3391 Rev: AA G

am 08.08.20 ①

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

S 08/08/21

| | | |
|-----|-------|--------------------------------|
| 4.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS
 1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: G

2-Deburr

SS 08/09/02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & Initial all entries

Date: Wednesday, 13/08/2008 10:10:36 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 41193

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

28 08/08/03

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

29 08/09/03

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

27 08-09-04

8.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

27 08-09-04

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

02/09/04

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.

7-Deburr

27 08-09-04

Tools: rill

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:10:37 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 41193

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

See 08/08/08 @

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AUM 8-9-9

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D M 8-9-9

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

SPACER

batch:

B 2818

D M 8-9-9

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Instal spacers as per dwg D3391

A/R Magnabond 6398 Batch: n108766

exp. date: 9-10-1

cure time 12hrs as per QSI0015

M 8-9-9

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

See 08/09/15 @

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:30pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:00pm

HL

08-09-15

@

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:10:37 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 41193

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-h 08/09/16 (N)

19.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Aft Cap

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 1 | D2646 | Aft Cap | |

B32427 *m-h*

20.0

D35371

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPAD

B38941 *m-h*

21.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearpad

B33869 *m-h*

22.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

B31630 *m-h*

23.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

B33870 *m-h*

24.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

PHENOLIC WASHER

B39275 *m-h*

25.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

INSERT

batch:

M105819

m-h 08/09/16 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:10:37 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 41193

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

or equivalent per
QSI 017

26.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

or equivalent

Per QSI 017

M100489

M. J.

27.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 2 | AN3C4A | Bolt | |

M109148

M. J.

28.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

M108744

M. J.

29.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 2 | AN960C10L | Washer | |

M108255

M. J.

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date:

M108801
08/10

M. J. 08/04/16

(1X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 41193

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/05 @

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPD 91689 PC 8/11/07 (C)

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/10

Job Completion



MF 08-11-07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | |
|--|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 41193 |
| Description: Float Skidtube (412) | | Part Number: D3391-3 |
| Inspection Dwg: D3391 | Rev: G | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 14.000 | +/-0.010 | 14.000 | ✓ | | | |
| 3.500 | +/-0.010 | 3.497 | ✓ | | | |
| 88.93 | +/-0.030 | 88.930 | ✓ | | | |
| 44.995 | +/-0.030 | 44.995 | ✓ | | | |
| 3.200 | +/-0.010 | 3.202 | ✓ | | | |
| 1.526 | +0.000/-0.030 | 1.518 | ✓ | | | |
| 0.200 | +/-0.010 | .204 | ✓ | | | |
| 7.500 | +/-0.010 | 7.498 | ✓ | | | |
| 27.750 | +/-0.010 | 27.750 | ✓ | | | |
| 31.750 | +/-0.010 | 31.750 | ✓ | | | |
| 35.250 | +/-0.010 | 35.250 | ✓ | | | |
| 3.300 | +/-0.010 | 3.295 | ✓ | | | |
| 0.200 | +/-0.010 | | | | | |
| 3.520 | +/-0.010 | 3.513 | ✓ | | | |
| 0.687 | +0.010/-0.000 | .687 | ✓ | | | |
| R0.062 | +/-0.010 | .062 | ✓ | | | |
| Ø0.484 | +0.005/-0.001 | .488 | ✓ | | | |
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|-------------------------------|--------------------------------|----------------------------|-----|
| Measured by: A.M./S.F. | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 08.08.21 | Date: 08/09/03 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|-------------|
| A | 06.04.24 | New Issue P/O D3391-015/-025 | KJ/JLM | |
| B | 06.06.19 | Dwg revision update | KJ/JLM | |
| C | 07.04.20 | Ø0.208 dimension removed | KJ/JLM | |
| D | 07.09.06 | 0.400 dimension removed | KJ/JLM | |
| E | 07.11.23 | Dwg Rev. updated | KJ/EC/DD | [Signature] |

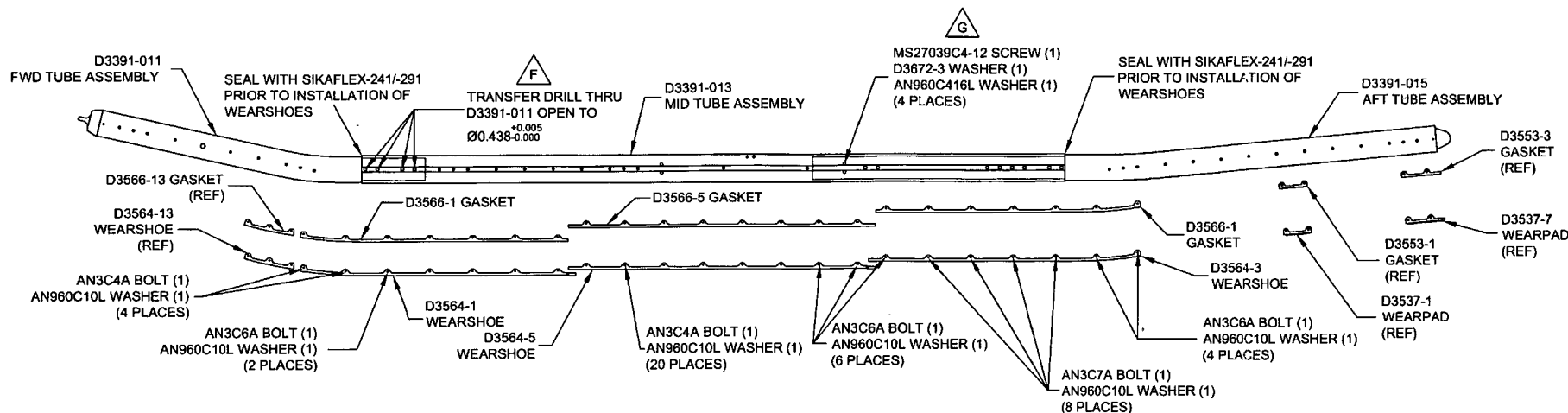
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



RELEASED
07-11-06

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY | PART NUMBER | DESCRIPTION |
|-----|--------------|-------------------------|
| 1 | D3391-041 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | D3391-011 | FWD TUBE ASSEMBLY |
| 1 | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D3391-015 | AFT TUBE ASSEMBLY |
| 1 | D3564-1 | WEARSHOE |
| 1 | D3564-3 | WEARSHOE |
| 1 | D3564-5 | WEARSHOE |
| 2 | D3566-1 | GASKET |
| 1 | D3566-5 | GASKET |
| 4 | D3672-3 | WASHER |
| 24 | AN3C4A | BOLT |
| 12 | AN3C6A | BOLT |
| 8 | AN3C7A | BOLT |
| 44 | AN960C10L | WASHER |
| 4 | MS27039C4-12 | SCREW |
| 4 | AN960C416L | WASHER |

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

| | | | |
|------------|---|----|----------|
| G | REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY | DC | 07.07.31 |
| F | ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021 | PH | 07.01.18 |
| E | CHANGE TOLERANCE, EASE MANUFACTURE | PH | 06.04.25 |
| D | UPDATE TOLERANCE, CHANGE HOLE SIZE | PH | 06.01.23 |
| C | LENGTHEN AFT EXTENSION | PH | 05.09.27 |
| B | DRAWING UPDATES | PH | 05.06.10 |
| A | NEW ISSUE | PH | 05.02.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 07.07.31 | | |

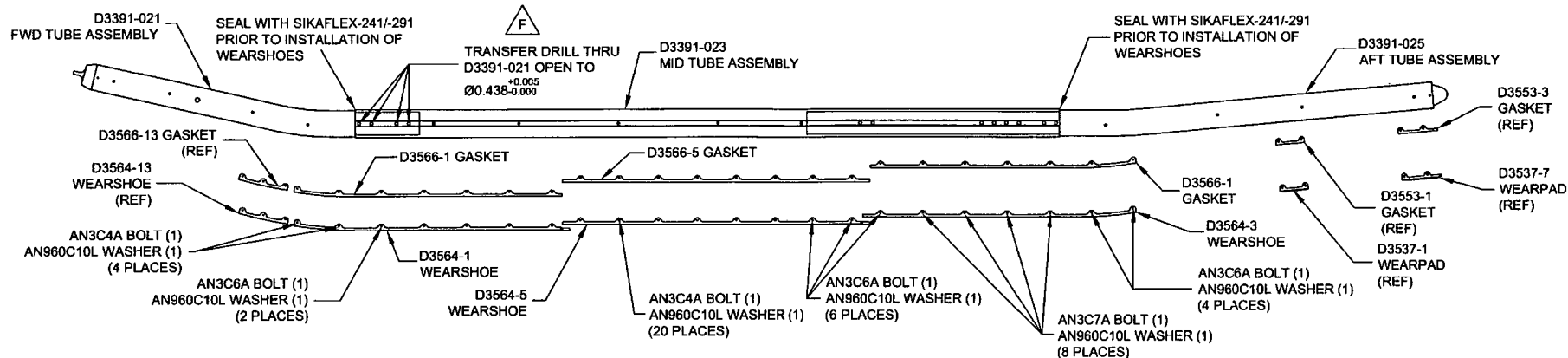
DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3391 REV. G
SHEET 1 OF 8

TITLE 412 FLOAT SKIDTUBE SCALE NTS

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 41193



D3391-043 ASSEMBLY

RELEASED
07.11.93

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

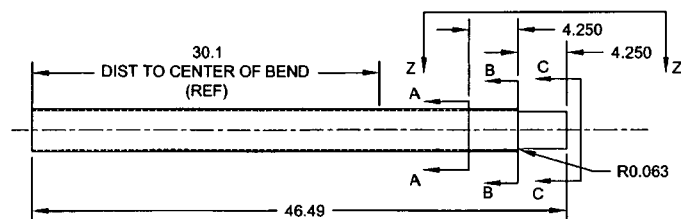
| QTY | PART NUMBER | DESCRIPTION |
|-----|-------------|-------------------------|
| X | D3391-043 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | D3391-023 | MID TUBE ASSEMBLY |
| 1 | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | D3564-1 | WEARSHOE |
| 1 | D3564-3 | WEARSHOE |
| 1 | D3564-5 | WEARSHOE |
| 2 | D3566-1 | GASKET |
| 1 | D3566-5 | GASKET |
| 24 | AN3C4A | BOLT |
| 12 | AN3C6A | BOLT |
| 6 | AN3C7A | BOLT |
| 44 | AN960C10L | WASHER |

GENERAL NOTES

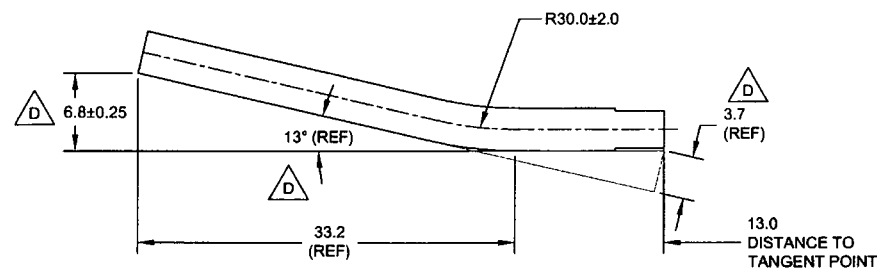
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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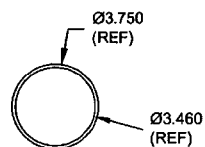
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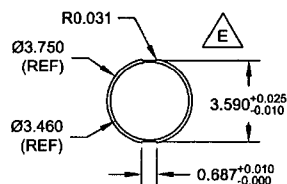
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(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



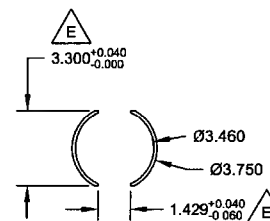
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



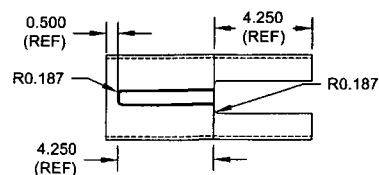
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(SCALE 1:5)



SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)

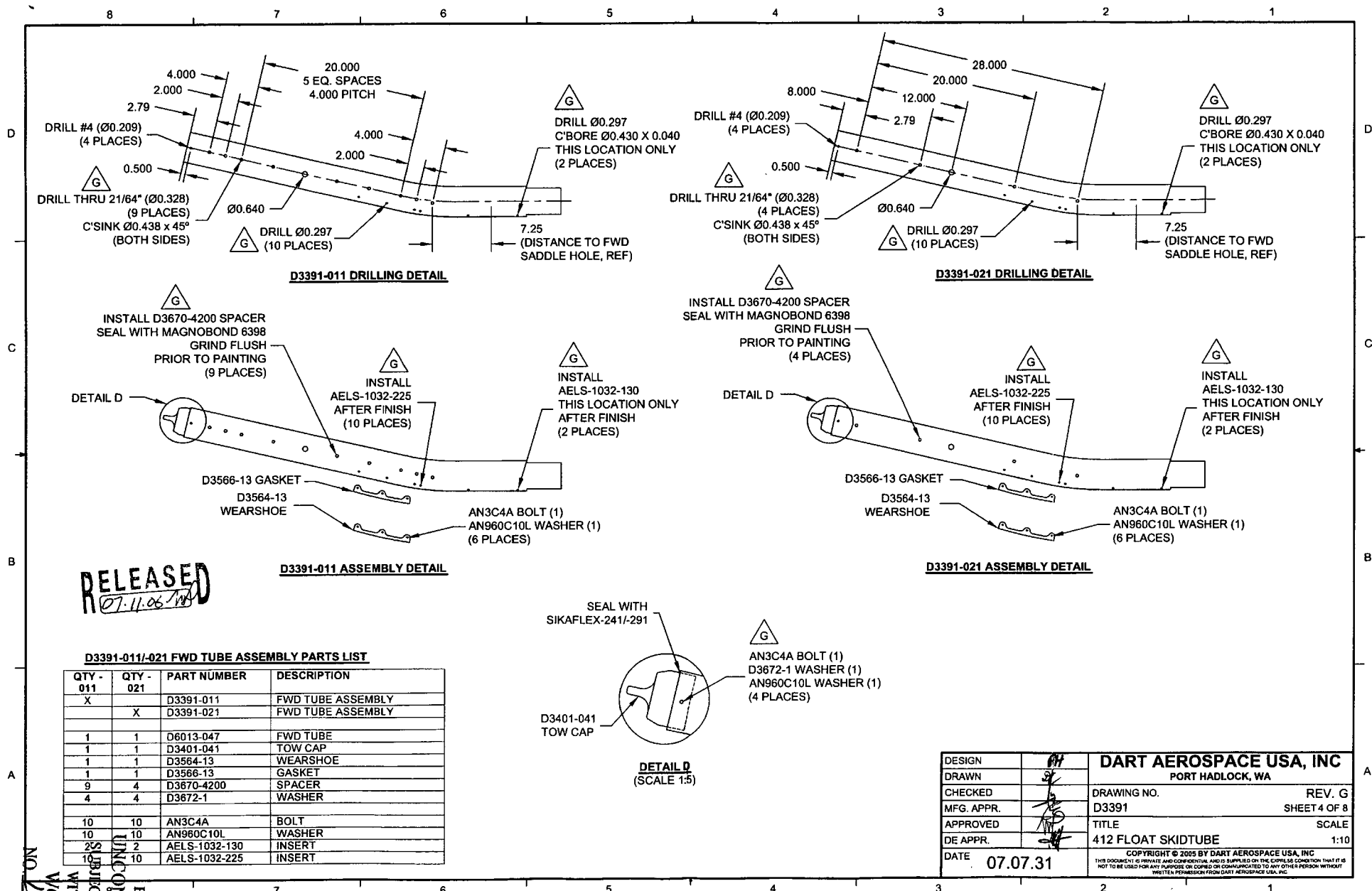


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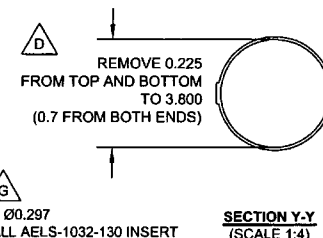
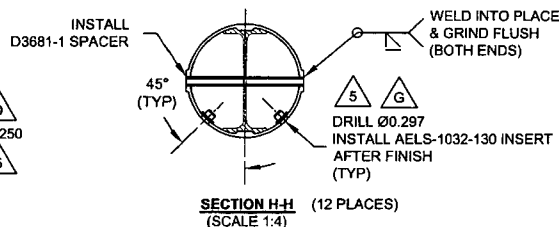
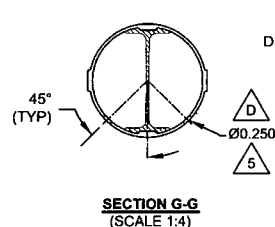
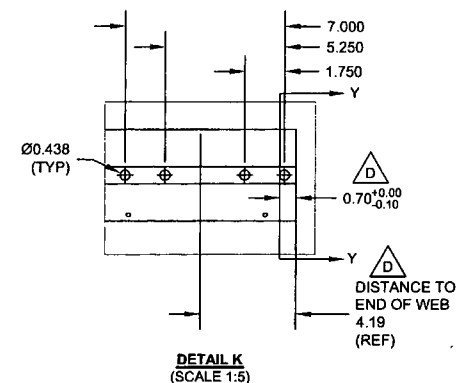
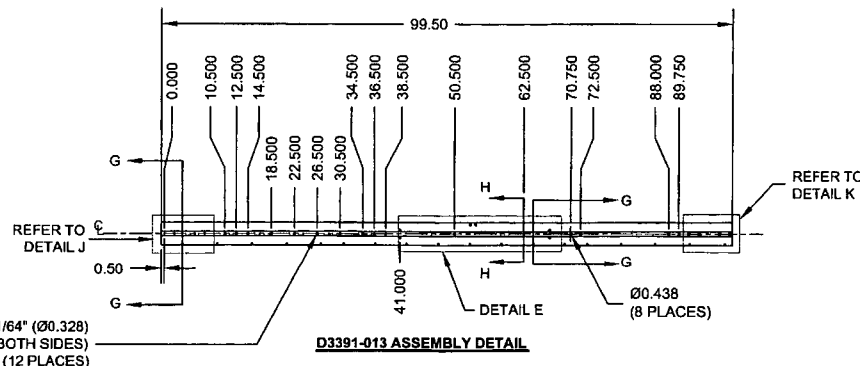
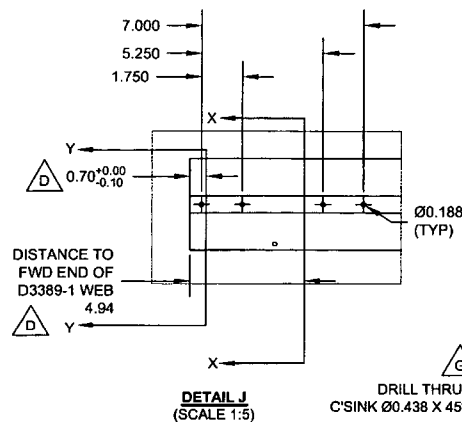
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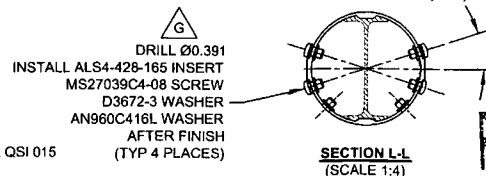
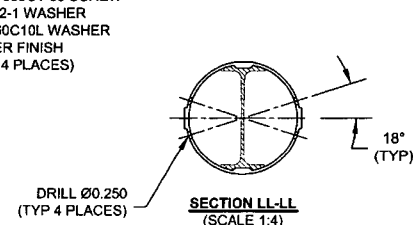
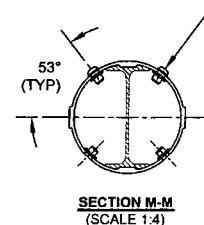
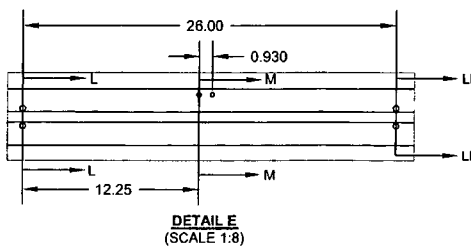
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

| QTY -013 | PART NUMBER | DESCRIPTION |
|----------|---------------|-------------------|
| X | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 12 | D3681-1 | SPACER |
| 4 | D3672-1 | WASHER |
| 4 | D3672-3 | WASHER |
| 24 | AELS-1032-130 | INSERT |
| 4 | ALS4-428-165 | INSERT |
| 4 | AN960C10L | WASHER |
| 4 | AN960C416L | WASHER |
| 4 | MS27039C1-09 | SCREW |
| 4 | MS27039C4-08 | SCREW |

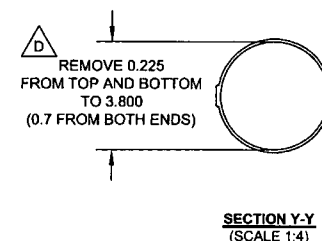
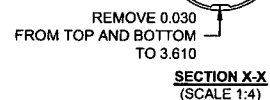
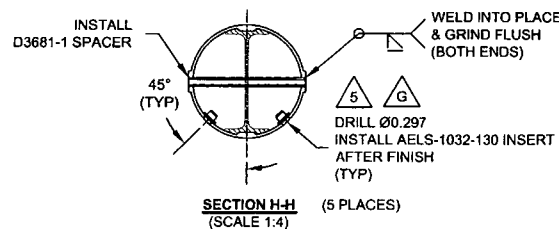
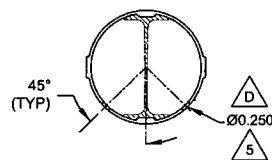
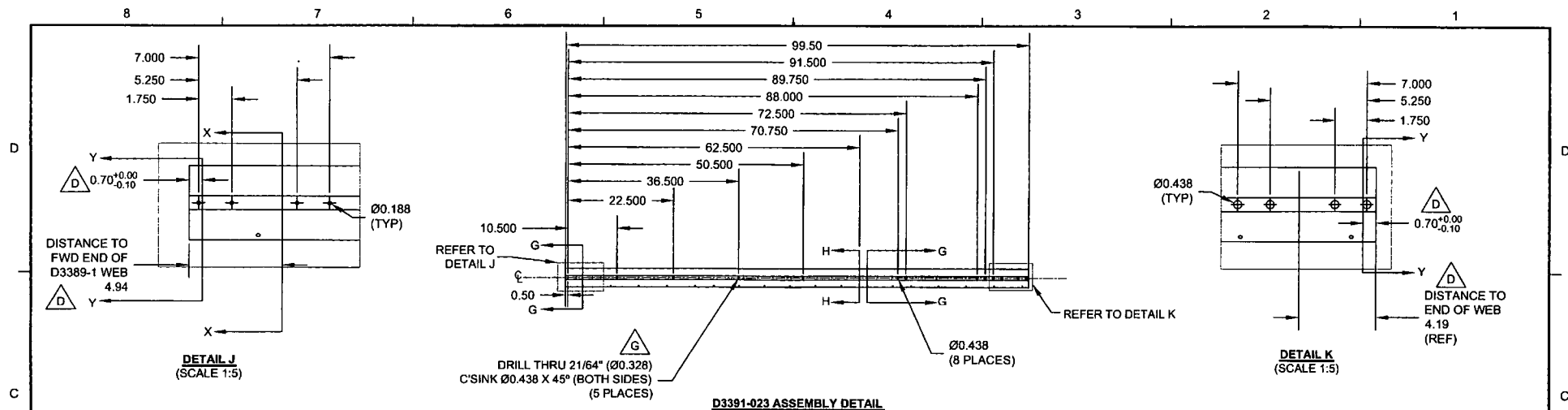


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D3391-013 MID TUBE ASSEMBLY
MATERIAL: TAKE FROM D2500-1-100 EXTRUSION
INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
WELDING: PER DART QSI 004
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D3391-023 MID TUBE ASSEMBLY PARTS LIST

| QTY - 023 | PART NUMBER | DESCRIPTION |
|-----------|---------------|-------------------|
| X | D3391-023 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 5 | D3681-1 | SPACER |
| 20 | AELS-1032-130 | INSERT |

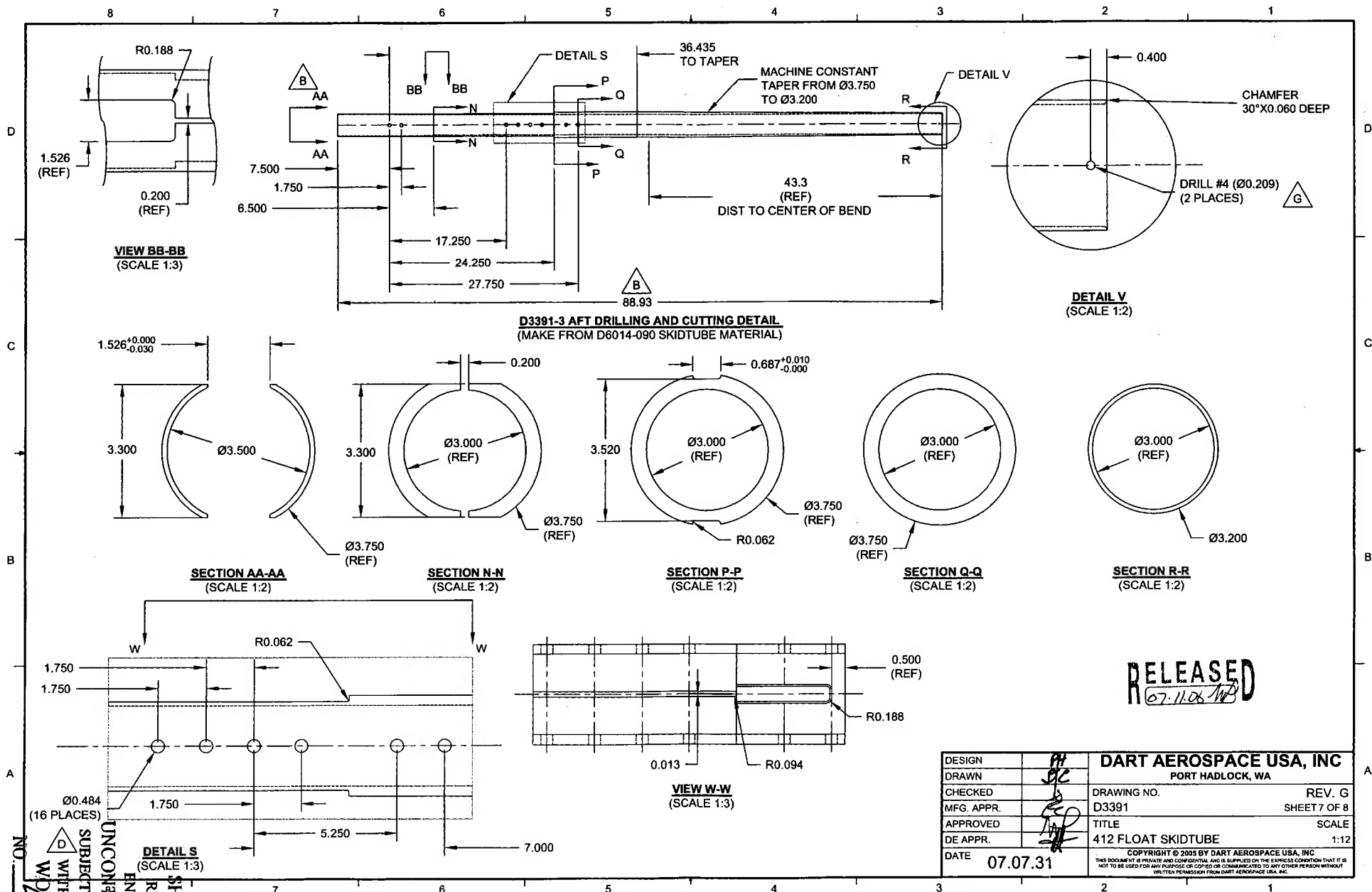
D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-2411-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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07.11.06/11

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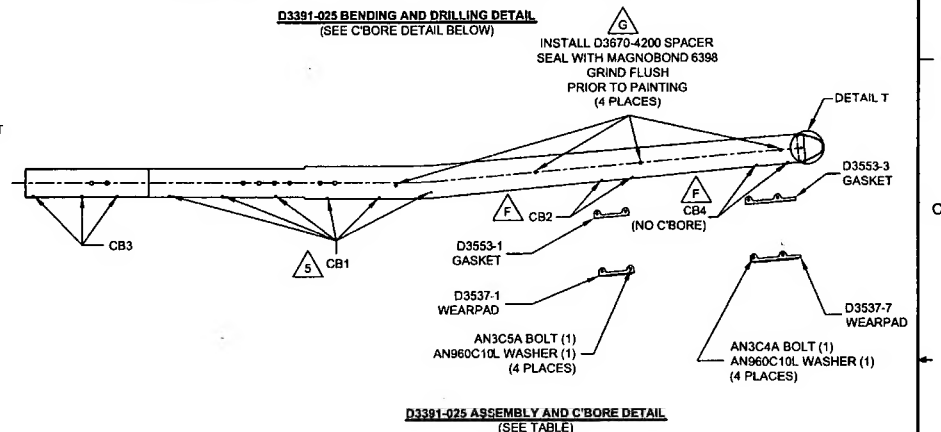
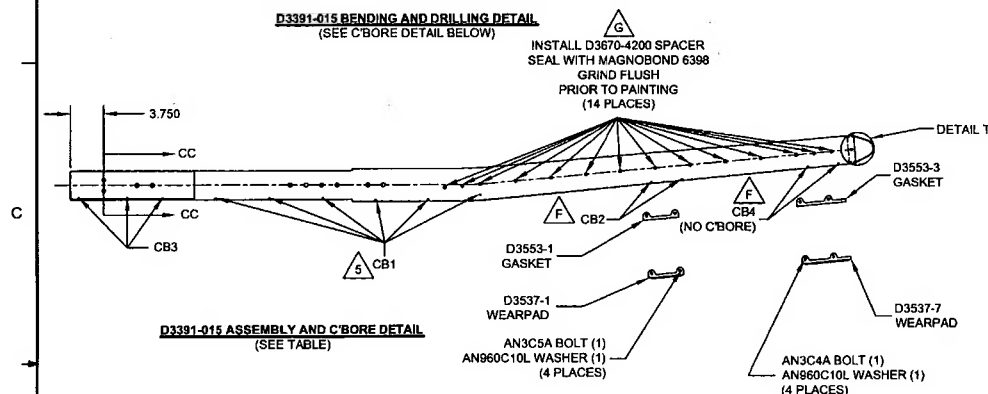
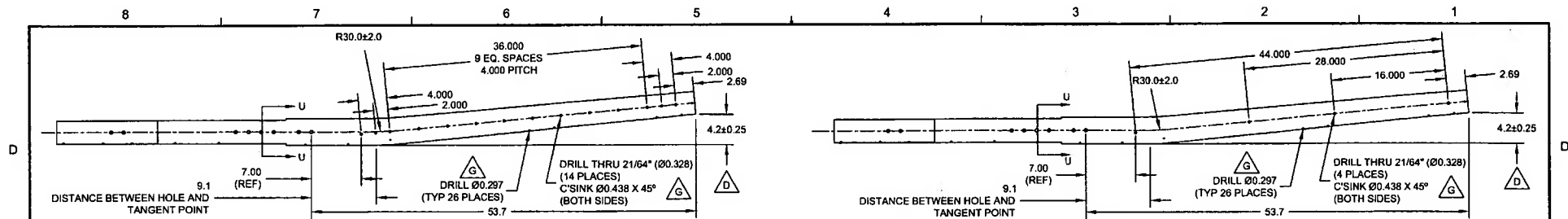
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| DE APPR. | | SCALE 1:12 |
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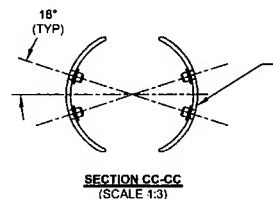
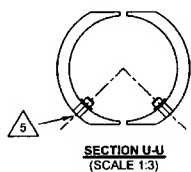
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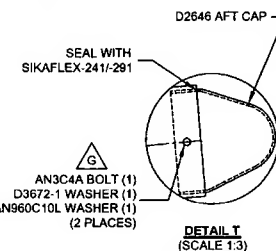


D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

| QTY - 015 | QTY - 025 | PART NUMBER | DESCRIPTION |
|-----------|-----------|---------------|-------------------|
| X | X | D3391-015 | AFT TUBE ASSEMBLY |
| | | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | 1 | D6014-090 | AFT TUBE |
| 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | D3537-1 | WEARPAD |
| 1 | 1 | D3537-7 | WEARPAD |
| 1 | 1 | D3553-1 | GASKET |
| 1 | 1 | D3553-3 | GASKET |
| 14 | 4 | D3670-4200 | SPACER |
| 2 | 2 | D3672-1 | WASHER |
| 14 | 14 | AELS-1032-130 | INSERT |
| 12 | 12 | AELS-1032-225 | INSERT |
| 4 | 4 | ALS4-428-165 | INSERT |
| 6 | 6 | AN3C4A | BOLT |
| 4 | 4 | AN3C5A | BOLT |
| 10 | 10 | AN960C10L | WASHER |



DRILL Ø0.391
C'BORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT (1)
(4 PLACES)



RELEASED
07-11-06

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | C'BORE | P/N |
|--------------|---------------|---------------|----------------|---------------|
| CB1 | 12 | 12 | Ø0.430 X 0.170 | AELS-1032-225 |
| CB2 | 4 | 4 | Ø0.430 X 0.170 | AELS-1032-130 |
| CB3 | 6 | 6 | Ø0.430 X 0.040 | AELS-1032-130 |
| CB4 | 4 | 4 | NONE | AELS-1032-130 |

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